

Work Order ID 76041

76041

Page 1

November-03-11 10:40:54 AM

Item ID: D3272-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step
 Start Date: 03/11/2011 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 01/12/2011 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: M.C.J Date: 11/11/03 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: 11/11/09 Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3272 | Rev B | | | | | | | | |

100 0.00
100 Large Fab
 Large Fab
 Large Fab
Memo 0.00
 SQUARE ONE END BEFORE CUTTING OTHER END
 1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A
 2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.
 3-Deburr

110 0.00
110 QC6- Inspect dimensions to drawing
 QC
 Quality Control
Memo 0.00

11-11-09 10 φ

11-11-09 10x φ

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

November-03-11 10:40:54 AM

Item ID: D3272-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Step

Stop ***NS2***

Start Date: 03/11/2011 **Start Qty:** 10.00

10

Cust Item ID:

Required Date: 01/12/2011 **Req'd Qty:** 10.00

10

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

| Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---------|--------|-----------|------------|------------|---------------|-------------|
|---------|--------|-----------|------------|------------|---------------|-------------|

120

Identify as per dwg & Stock Location: W4

0.00

120

Packaging

Memo

0.00

Packaging

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

11-11-11
(10)

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NOTE: Date & initial all entries

Picklist Print

November-03-11 10:40:58 AM

Page 1

Work Order ID: 76041

76041

Parent Item: D3272-1

D3272-1

Parent Item Name: Step

Start Date: 03/11/2011

Required Date: 01/12/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-06-09 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|-----------------|--------|
| D2622-120C | | Manufactured | No | | | 100 | Each | 58.0200 | 1 | 10 | | | |
| *D2622-120C* | | | | | | | | | ** | | | <i>11.11.90</i> | |
| Step Extrusion | | | | | | | | | | | | | |

Location

Loc Qty

Loc Code

HALL

48.32

64409

6

68293

0.5

72131

41.82

WA

9.7

46910

2

66970

7.7

10

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NOTE: Date & initial all entries



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|----------------------|--------------------------------|--|------------------------|
| DESIGN <i>qp</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>LE</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3272 | REV. B SHEET 1 OF 3 |
| DATE 07.05.18 | | TITLE STEP ASSEMBLY, HI LONG SCALE NTS | |
| A | 04.03.01 | NEW ISSUE | |
| B | 07.05.18 | D3272-1 WAS D2622-120 | |

RELEASED

07.06.04 *[Signature]*

| QTY -041 | QTY -042 | PART NUMBER | DESCRIPTION |
|-------------|-------------|--------------|-------------------------------|
| X | | D3272-041 | STEP ASSEMBLY, HIGH LONG (LH) |
| | X | D3272-042 | STEP ASSEMBLY, HIGH LONG (RH) |
| | | | |
| 1 | 1 | D3065-041 | LEG ASSEMBLY |
| 2 | 2 | D3066-1 | SPACER |
| 2 | 2 | D3067-1 | END PLATE |
| 2 | 2 | D3219-1 | SUPPORT |
| 1 | 1 | D3272-1 | STEP |
| | | | |
| 16 | 16 | MS20600AD4W4 | RIVET |
| | | | |

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 76041 M.C.J

1111/03

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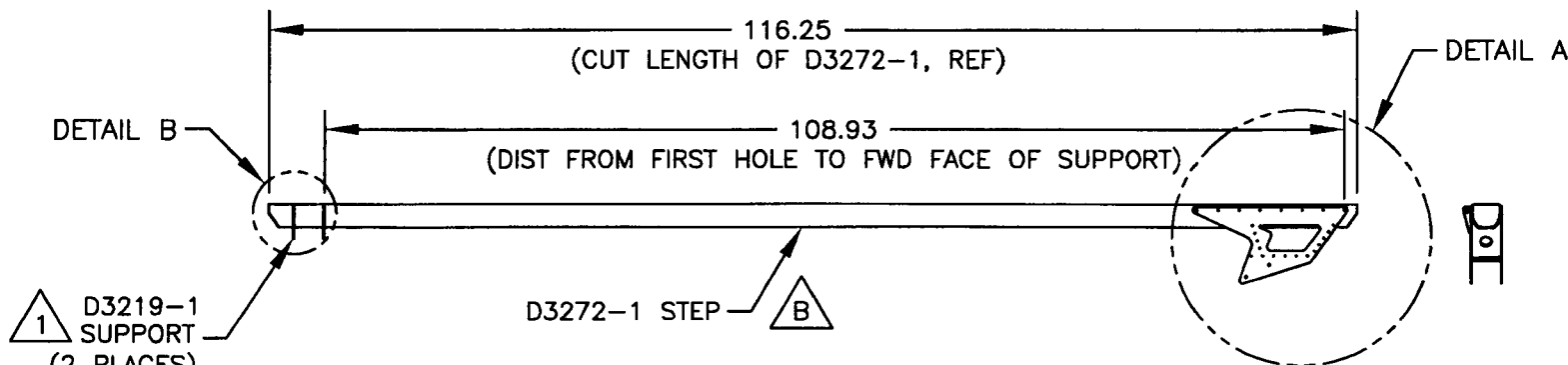
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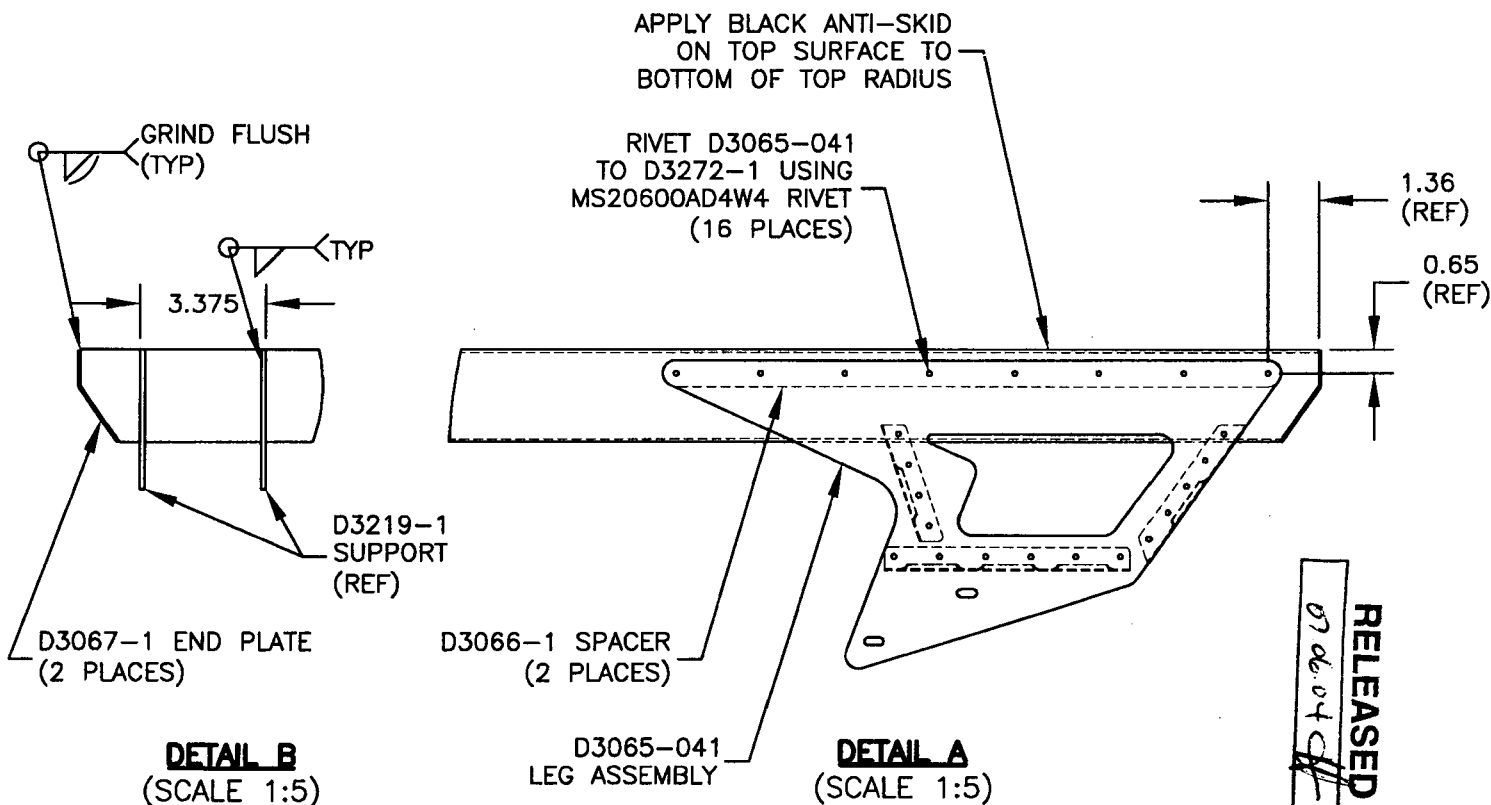
DART

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|---------|----------|-------------|------------------------|-----------------------------|--------------|
| DESIGN | 49 | DRAWN BY | | DART AEROSPACE LTD | REV. B |
| CHECKED | CE | APPROVED | | HAWKESBURY, ONTARIO, CANADA | |
| DATE | 07.05.18 | DRAWING NO. | D3272 | | SHEET 2 OF 3 |
| | | TITLE | STEP ASSEMBLY, HI LONG | | SCALE |
| | | | | | 1:20 |



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



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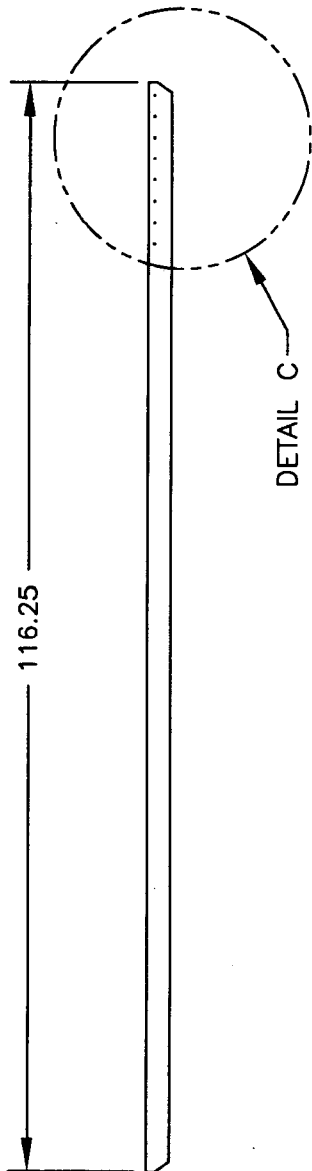


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|------------------|---------------------------------|---|------------------------|
| DESIGN GP | DRAWN BY JB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED LE | APPROVED H | DRAWING NO. D3272 | REV. B SHEET 3 OF 3 |
| DATE 07.05.18 | TITLE STEP ASSEMBLY, HI LONG | | SCALE 1:20 |

RELEASED

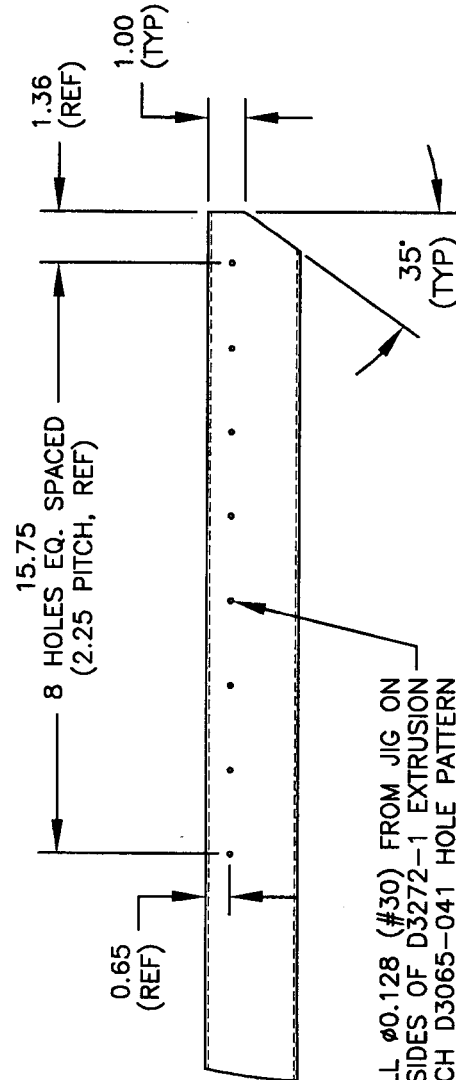
07.06.04



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C

(SCALE 1:5)

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